

Work Order ID 65565

January 19, 2011 1:58:18 PM



Page 1

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

8/1/01/21

OK for ch 11/01/21

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

ensure tension to retract step is 11 to 18 lbs before installing lockwire.

A/R-MS20995C41 batch: M101537

ES 11/01/20 @

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

***ensure tension to retract step is 11 to 18 lbs ***

Test fit on aircraft in Eng. lab.

8/1/01/20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65565

Page 2

January 19, 2011 1:58:18 PM

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/2011

P

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulalzi

4
RH

150

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-032

Location:

PPP Rev:

31 D

11/1/21

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65565

Page 3

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Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/24
MF
11-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2011 1:56:34 PM

Page 1
8

Work Order ID: 65565



Parent Item: D412-630-032



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
10.05.28 added route seq DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 		Purchased	No			130	Each	28.0000	1	1			
NUT													

Location Loc Qty Loc Code

ST324 28
116075 28

AN310-5 		Purchased	No			130	Each	47.0000	2	2			
NUT													

Location Loc Qty Loc Code

ST324 47
114830 47

AN3C5A 		Purchased	No			130	Each	1,028.000	3	3			
Bolt													

Location Loc Qty Loc Code

ST350 1028
114330 11
115015 13
115371 100
115422 100
115594 6
115835 198
116419 500
116549 100

3

Picklist Print

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Page 2

Work Order ID: 65565

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

AN44-C12

Purchased

No

130

Each

11.0000



eyebolt

11/1/2011

Location

Loc Qty

Loc Code

ST362

11

114669

11

AN4C15

Purchased

No

130

Each

19.0000



BOLT

11/1/2011

Location

Loc Qty

Loc Code

ST358

19

114669

19

AN5C14

Purchased

No

130

Each

41.0000



BOLT

11/1/2011

Location

Loc Qty

Loc Code

ST337

41

113950

11

114801

30

AN5C15

Purchased

No

130

Each

17.0000



BOLT

11/1/2011

Location

Loc Qty

Loc Code

ST338

17

114669

17

AN960C10

NAS1149C0363
R

Purchased

No

130

Each

0.0000



WASHER

11/1/2011

January 19, 2011 1:56:34 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 65565

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

AN960C516

Purchased No

130 Each

159.0000



WASHER

Location

Loc Qty

Loc Code

ST347

159

102842

59

112532

100

D3454-1

Manufactured No

130 Each

26.0000



Bushing

Location

Loc Qty

Loc Code

ST058

26

58555

26

D3454-3

Manufactured No

130 Each

25.0000



Bushing

Location

Loc Qty

Loc Code

ST058

25

56420

25

D3454-5

Manufactured No

130 Each

8.0000



Bushing

Location

Loc Qty

Loc Code

ST058

8

58556

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 65565

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

D3455-1

Manufactured No

130 Each

28.0000



Spacer



4
11/12/08

Location

Loc Qty

Loc Code

ST058

28

56525

3

59469

25

D3455-3

Manufactured No

130 Each

15.0000



Spacer



2
11/12/08

Location

Loc Qty

Loc Code

ST058

15

56047

7

58559

8

D3462-042

Manufactured No

130 Each

6.0000



Bracket Assembly



1
11/12/08

Location

Loc Qty

Loc Code

ST198A

6

35860

1

59471

5

MS21043-3

Purchased No

130 Each

1,677.000



Nut



3
11/12/08

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1601

112314

1601

3

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 65565

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

MS24665-227

Purchased

No

130

Each

38.0000

COTTER PIN

Location

Loc Qty

Loc Code

ST309

38

113845

38

Each

27.0000

MS24665-302

Purchased

No

Cotter Pin

Location

Loc Qty

Loc Code

ST309

27

113644

27

Each

184.0000

NAS1515H5

Purchased

No

Washer

Location

Loc Qty

Loc Code

FG

44

103286

17

103691

27

ST277

140

109430

140

Each

28.0000

D3455-1

Manufactured

No

Spacer

Location

Loc Qty

Loc Code

ST058

28

56525

3

59469

25

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 65565

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

D3443-041

Manufactured No

110 Each

4.0000

1

1



Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

4

56061

4

D3463-042

Manufactured No

110 Each

3.0000

1

1



Step Weldment Assembly

Location

Loc Qty

Loc Code

ST494

3

62561

3

D3443-9

Manufactured No

110 Each

6.0000

2

2



Pin

Location

Loc Qty

Loc Code

ST056

6

58552

6

AN4C14

Purchased No

110 Each

22.0000

1

1



BOLT

Location

Loc Qty

Loc Code

ST358

22

113899

2

114669

20

MS24665-229

Purchased No

130 Each

167.0000

2

2



COTTER PIN

Location

Loc Qty

Loc Code

ST309

167

111041

167

January 19, 2011 1:56:37 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 65565

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

MS24665-227

Purchased No

110 Each

38.0000

1



COTTER PIN

Location

Loc Qty

Loc Code

ST309

38

113845

38

AN4CH3

Purchased No

110 Each

18.0000

2



SS Bolt

Location

Loc Qty

Loc Code

ST355

18

114801

18

D3465-1

Manufactured No

110 Each

26.0000

1



Washer

Location

Loc Qty

Loc Code

ST059

26

46134

26

AN310-4

Purchased No

110 Each

28.0000

2



NUT

Location

Loc Qty

Loc Code

ST324

28

116075

28

D3443-043

Manufactured No

110 Each

3.0000

1



Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

3

56062

3

January 19, 2011 1:56:37 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2011 1:56:38 PM

Page 8

Work Order ID: 65565

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 1.00

Required Qty: 1.00

D3454-7

Manufactured No

110 Each

18.0000

2



Bushing

Location

Loc Qty

Loc Code

ST058

18

55608

1

59256

17

110 Each

49.0000

1

AN310-7

Purchased No



NUT

Location

Loc Qty

Loc Code

ST324

49

114784

49

2
E 5/11/01/20

2
1
E 5/11/01/20

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

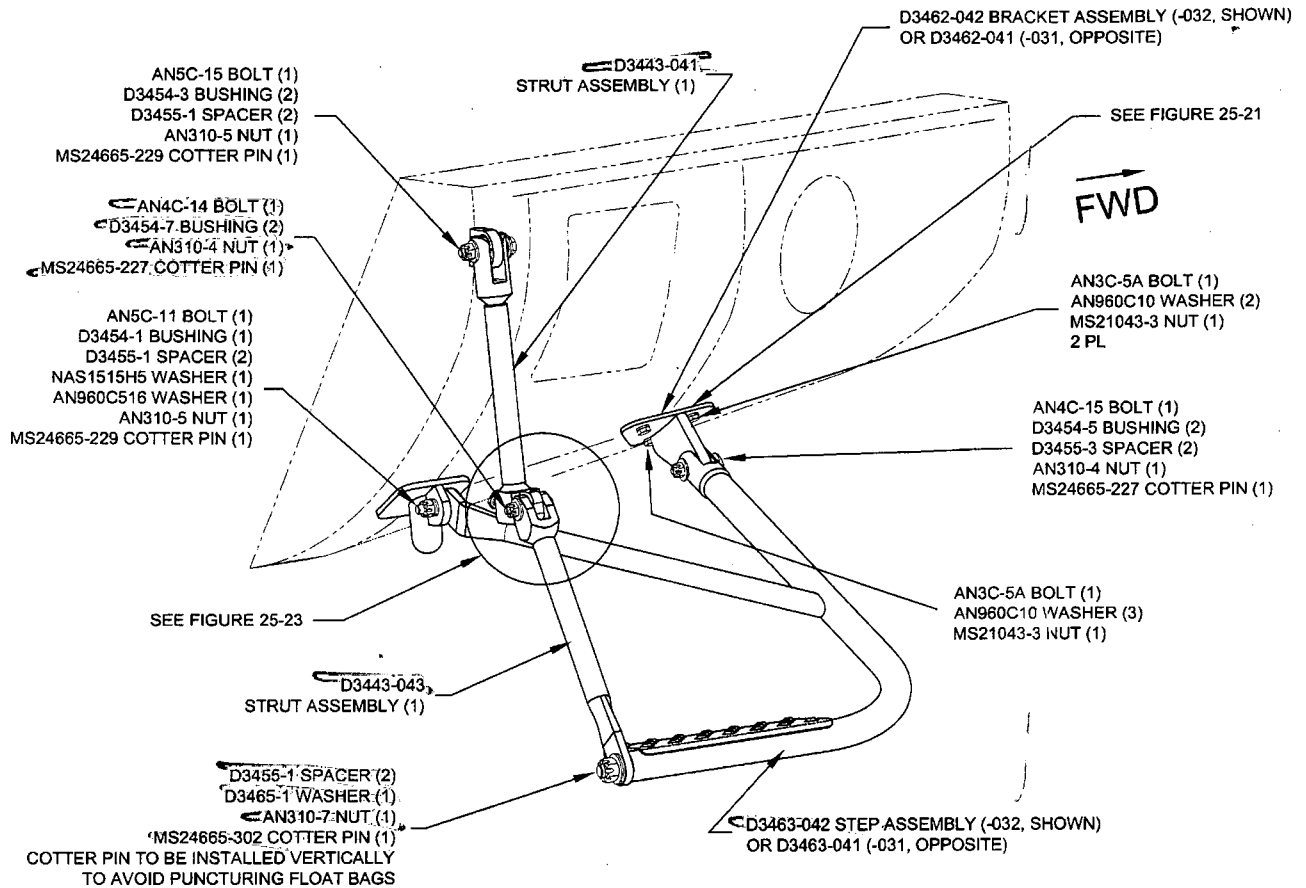


FIGURE 25-22: Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

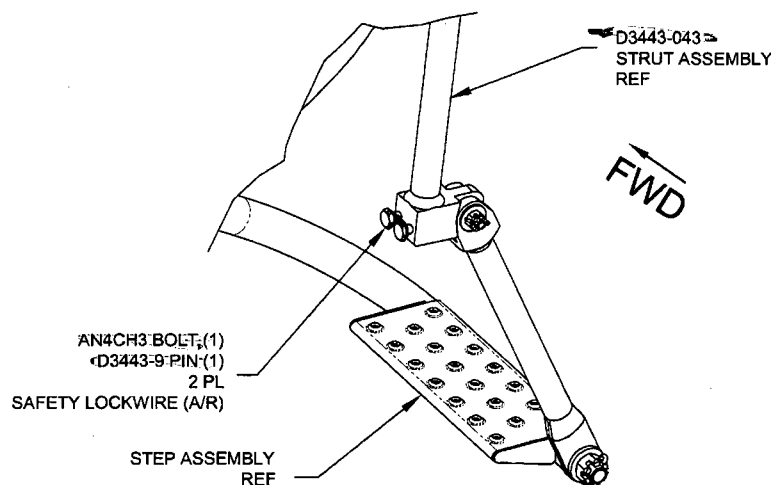


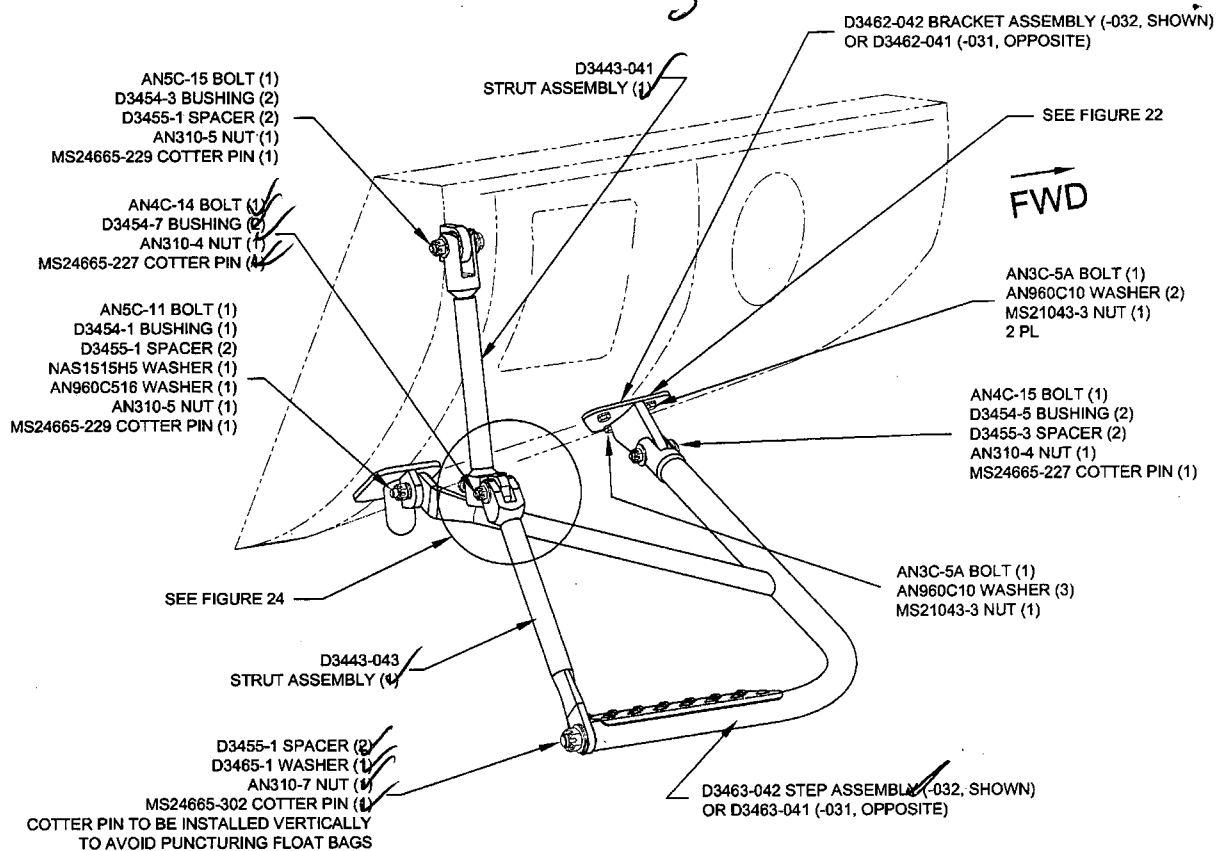
FIGURE 25-23: Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

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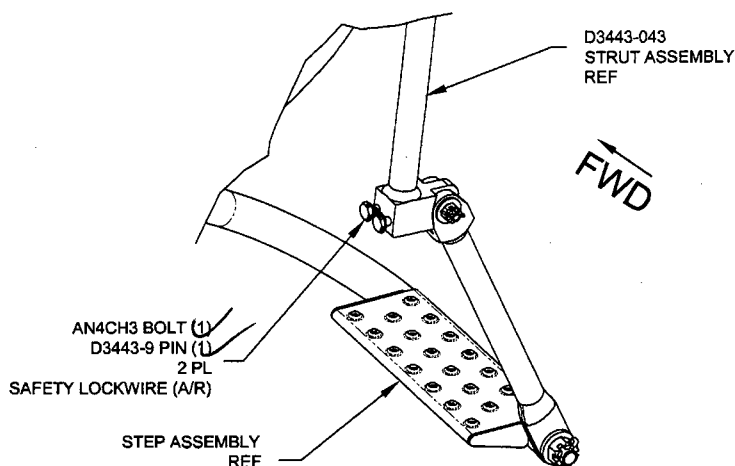
25-00-00

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN46-14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN -1
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP



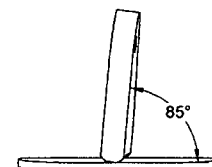
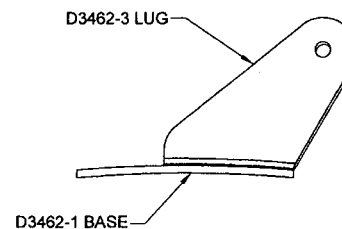
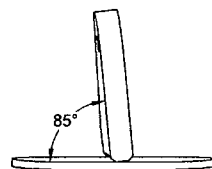
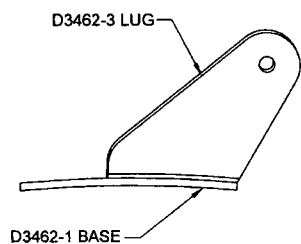
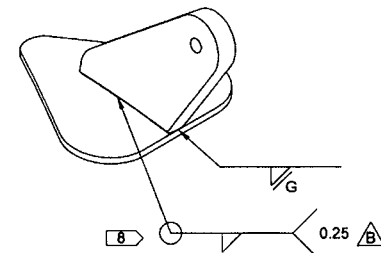
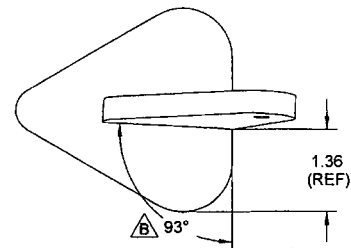
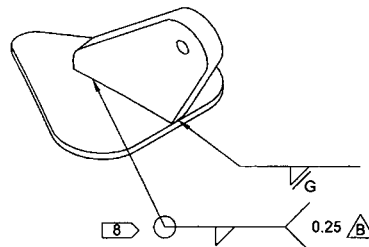
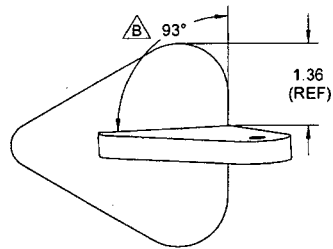
**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

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Revision: **M**
Date: 08.12.12



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

REFERENCE

RELEASED
080707 1370

DESIGN	REV. C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG	DC	07.10.24
DRAWN	1/10/24 DC	REASON: PRODUCTION FACILITY		
CHECKED	1/10/24	REVISE DIMENSIONS	RF	05.12.05
MFG. APPR.	1/10/24	NEW ISSUE	RF	05.09.20
APPROVED	1/10/24	REV. DESCRIPTION	BY	DATE
DE APPR.	1/10/24			
DATE	07.10.24			

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. C
D3462	SHEET 1 OF 2
TITLE	SCALE
BRACKET ASSEMBLY	1:2

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